



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

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D4881-042
Job Sheet 187113



Part No: D4881-042

Job Qty: 1 ea

Part Name: 206A/B AFT Leg Assembly, RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/28/18

Job Tracking No:

Due Date: 12/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEETS 3,4 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM IPP REV:B 14.07.07 AS PER
DWG REV.C DD VERF:JLM IPP REV:C 18.01.29 LASER ENGRAVE NOW MADE IN HOUSE DD VERF:JFS

Ship Via:

6811

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/14/18	12/14/18	0.00	0.00	Start Up Small Fab-4		DEC 12 2018
110	Small Fab	1 pcs	12/14/18	12/14/18	0.00	0.78	Small Fab-8		Smh
120	QC	1 pcs	12/14/18	12/14/18	0.00	0.00	QC5		38 DAS
130	Small Fab	1 pcs	12/14/18	12/14/18	0.00	0.78	Small Fab-8		9-88 58 DAS
140	QC	1 pcs	12/14/18	12/14/18	0.00	0.00	QC5		DEC 12 2018
180	Packaging	1 pcs	12/14/18	12/14/18	0.00	0.00	Packaging3-2		DEC 12 2018
190	QC21-SA	1 Ea	12/14/18	12/14/18	0.00	0.00	QC21		DEC 12 2018

Part Op 110 - ALIGN PILOT HOLES IN D4881-1 WITH PILOT HOLES IN D4885-2 AND D4885-3. DRILL OUT EACH HOLES
Descriptions: USING A PILOTED DRILL AS PER DWG. REAM EACH HOLES USING REAMER, USING DART TOOL SETUP DT9974
AS PER DWG.

130 - 1- INSTALL PIN/COLLAR AND END FITTING WITH HYSOL OR MAGNOBOND 6398 WHILE STILL WET AS PER
DWG USE DT9974 A/R BATCH: 580785 2- LASER ENGRAVE ASSEMBLY PART#, S/N AS PER DWG
QSI 44 6.8

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4881-1	Strut	1 Ea (1 ea)	90-Start up Operation	5133248
D4885-2	End Fitting	1 Ea (1 ea)	90-Start up Operation	5124006
D4885-3	End Fitting	1 Ea (1 ea)	90-Start up Operation	5128634
HL32PB5-12	Hi-Lok Pin	4 Ea (4 ea)	90-Start up Operation	5116810
HL86-5	Hi-Lok Collar	4 pcs (4 ea)	90-Start up Operation	510876

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4881-1	1	6	0
	D4885-2	1	8	0
	D4885-3	1	6	0
	HL32PB5-12	4	110	0
	HL86-5	4	161	0

Part Specifications

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____ Work Order update

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PR	
Part No. _____		Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐
NCR No. _____			Prod. I ☐ Rec/Store/ ☐

Date : _____	Step #: _____	QTY Effective : _____
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Description Work Order Deviation	Disposition

Instructions: Various STC's

Date: 12/06/18

Revision: _____
 Inspector: _____
 Exp Date: _____
 Part: D4881 - 042
 Job No: 187113
 Serial No/ Batch: S135196



Container No: S135196



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Approval

Root Cause			FAULT CATEGORY		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Specifications could not be found.

Plex 11/28/18 7:04 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

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